# Work Order ID 101610

*101610*



*May-13-13 1:09:55 PM*

**Item ID:** D350-567-141 **Accept** *N900040100* **Setup Start** *NS1*

**Revision ID:** **Stop** *NS2*

**Item Name:** Floor Window Closeout Installation

**Start Date:** 5/31/13 **Start Qty:** 2.00 *2*

**Required Date:** 5/31/13 **Req'd Qty:** 2.00 *2*

**Reference:**

**Cust Item ID:**

**Customer:**

**Run Start** *NR1*

**Stop** *NR2*

**Approvals:** **Process Plan:** MLJ **Date:** 13-05-15 **Tooling:** _____ **Date:** _____

**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| **Draw Nbr** | **Revision Nbr** | | | | | | | | |
| DSI 9590 | C | | | | | | | | |
| 100 | DOCUMENT CONTROL | 0.00 | | | | 2 | | | |
| *100* | | | | | | | | | |
| DC | **Memo** | 0.00 | | | | | | | |
| Document Control | Photocopy bluefile & type labels per PPP D350-567-141 CHG002 | | | | | | | | |
| 110 | Pick Kit | 0.00 | | | | 2x | | | SP |
| *110* | | | | | | 13-6-13 | | | |
| Packaging | **Memo** | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |
| 120 | QC4- 100% Inspect kits for completeness | 0.00 | | | | 2 | | | |
| *120* | | | | | | | | | |
| QC | **Memo** | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

DQA: _____ Date: _____

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

**AGAINST DEPARTMENT/PROCESS**

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

| Root Cause | | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Setup | ☐ | | | | | | | | | |
| Other | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

**FAULT CATEGORY**

**Landing Gear**

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

**General**

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

**Item ID:** D350-567-141 **Accept** *N900040100* **Setup Start** *NS1*
**Revision ID:** **Stop** *NS2*
**Item Name:** Floor Window Closeout Installation

**Start Date:** 5/31/13 **Start Qty:** 2.00 *2* **Cust Item ID:**
**Required Date:** 5/31/13 **Req'd Qty:** 2.00 *2* **Customer:**
**Reference:**

**Run Start** *NR1*
**Stop** *NR2*

**Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 130 | | 0.00 | | | | | | | |
| *130* | Packaging | | | | | | | | |
| Packaging | **Memo** | 0.00 | | | | | | | |
| Packaging | Identify and pack for shipping as per PPP D350-567-141<br>Location: 059A | | | | | | 13/6/18 | | SD |
| 140 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *140* | | | | | | | | | |
| QC | **Memo** | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

MLS 13-06-18
MF
13-6-18

DQA: _____ Date: _____

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

Rework ☐
Scrap ☐
Use-as-is ☐
Work Order Update ☐

**AGAINST DEPARTMENT/PROCESS**

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

| Root Cause | | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Setup | ☐ | | | | | | | | | |
| Other | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

**FAULT CATEGORY**

**Landing Gear**

☐ Bending
☐ Centre Not Concentric to O/S
☐ Cracks
☐ Crushed/Crimped
☐ Cuffs
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Ripples in Bend
☐ Torque Waves in Extrusion
☐ Turning Sequence
☐ Wave/Twist in Tube

**General**

☐ Bend
☐ BOM/Route
☐ Broken/Damaged
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drill Holes
☐ Drawing
☐ Finish
☐ Folio

☐ Grain
☐ Hardware
☐ Inspection Incomplete
☐ Instructions Incomplete/Unclear
☐ Maintenance
☐ Mislabeled
☐ Misread
☐ Offset
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions

☐ Ovalized
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other _____

# Picklist Print



*May-13-13 1:09:54 PM*

**Work Order ID:** 101610
**Parent Item:** D350-567-141
**Parent Item Name:** Floor Window Closeout Installation

**Start Date:** 5/31/13 **Required Date:** 5/31/13
**Start Qty:** 2.00 **Required Qty:** 2.00

**Comments:** IPP REV:A 11.11.09 new issue DD verf:JLM IPP REV:B 12.01.23 AS PER ECN12-511 DD VERF:EC IPP REV:C 12.03.05 AS PER ECN12-537 DD VERF:EC

| Component Item ID / Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| D3802-1-624 Window Seal | | Manufactured | No | | | 110 | f | 272.3900 | 2 | 4 | | | |
| 24" parKit 2x24" SMP | | | | | | | | | | | | | |
| | | | | **Location** | | | | **Loc Qty** | | **Loc Code** | | | |
| | | | | ST408 | | | | 272.39 | | | | | |
| | | | | | 56881 | | | 0.75 | | | | | |
| | | | | | 81021 | | | 2 | | | | | |
| | | | | | 81868 | | | 269.64 | | | | | |
| D4434-041 Fwd Bracket Assembly | | Manufactured | No | | | 110 | Each | 1.0000 | 1 | 2 4x | B101756 | | |
| SMP 2x | | | | | | | | | | | | | |
| | | | | **Location** | | | | **Loc Qty** | | **Loc Code** | | | |
| | | | | ST272 | | | | 1 | | | | | |
| | | | | | 95149 | | | 1 | | | | | |
| D4434-047 Cover Assembly | | Manufactured | No | | | 110 | Each | 7.0000 | 1 | 2 | SP | | |
| SMP 2x | | | | | | | | | | | | | |
| | | | | **Location** | | | | **Loc Qty** | | **Loc Code** | | | |
| | | | | ST273 | | | | 7 | | | | | |
| | | | | | 95862 | | | 7 | | | | | |
| D4435-045 T/R Bellcrank Cover Assembly | | Manufactured | No | | | 110 | Each | 8.0000 | 1 2x | 2 | SP | | |
| SMP 2x | | | | | | | | | | | | | |
| | | | | **Location** | | | | **Loc Qty** | | **Loc Code** | | | |
| | | | | ST273 | | | | 8 | | | | | |
| | | | | | 96412 | | | 3 | | 2x | | | |
| | | | | | 96551 | | | 5 | | | | | |
| D4435-9 Bracket SMP 2x | | Manufactured | No | | | 110 | Each | 0.0000 | 2 | 4 | B101728 SP | | |
| D4436-041 Aft Bracket Assembly | | Manufactured | No | | | 110 | Each | 6.0000 | 1 | 2 | SP13-613 | | |
| SMP 2x | | | | | | | | | | | | | |
| | | | | **Location** | | | | **Loc Qty** | | **Loc Code** | | | |
| | | | | ST272 | | | | 6 | | | | | |
| | | | | | 101392 | | | 6 | | 2x | | | |

DQA: _____ Date: _____

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

**AGAINST DEPARTMENT/PROCESS**

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

| Root Cause | | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Setup | ☐ | | | | | | | | | |
| Other | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

**FAULT CATEGORY**

**Landing Gear**

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**General**

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- ☐ Cut Too Short
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- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
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- ☐ Power Loss/Surge
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- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

# Picklist Print

*May-13-13 1:09:54 PM*

**Work Order ID:** 101610
**Parent Item:** D350-567-141
**Parent Item Name:** Floor Window Closeout Installation
**Start Date:** 5/31/13 **Required Date:** 5/31/13
**Start Qty:** 2.00 **Required Qty:** 2.00

[redacted] =240
Rubber Seal — Manufactured — No — 110 — f — 411.4346

24" pcs Kit
2X24" Shp 2

| Location | | Loc Qty | Loc Code |
|---|---|---|---|
| ST412 | | 411.4346 | |
| | 74760 | 6.119 | |
| | 79385 | 0.0476 | |
| | 80763 | 35.656 | |
| | 86185 | 369.612 | |

[redacted]
Bolt — Purchased — No — 110 — Each — 162.0000

Shp 2

| Location | | Loc Qty | Loc Code |
|---|---|---|---|
| ST350 | | 162 | |
| | 123831 | 7 | |
| | 124221 | 130 | |
| | 124552 | 25 | |

[redacted]
Screw — Purchased — No — 110 — Each — 236.0000

Shp 2

| Location | | Loc Qty | Loc Code |
|---|---|---|---|
| ST343 | | 236 | |
| | 120560 | 236 | |

[redacted]
Nut — Purchased — No — 110 — Each — 637.0000

Shp 2

| Location | | Loc Qty | Loc Code |
|---|---|---|---|
| ST314 | | 137 | |
| | 124859 | 137 | |
| ST316 | | 500 | |
| | 125303 | 500 | |

DQA: _____ Date: _____

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

Rework ☐
Scrap ☐
Use-as-is ☐
Work Order Update ☐

**AGAINST DEPARTMENT/PROCESS**

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

| Root Cause | | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Setup | ☐ | | | | | | | | | |
| Other | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

**FAULT CATEGORY**

**Landing Gear**

☐ Bending
☐ Centre Not Concentric to O/S
☐ Cracks
☐ Crushed/Crimped
☐ Cuffs
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Ripples in Bend
☐ Torque Waves in Extrusion
☐ Turning Sequence
☐ Wave/Twist in Tube

**General**

☐ Bend
☐ BOM/Route
☐ Broken/Damaged
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drill Holes
☐ Drawing
☐ Finish
☐ Folio

☐ Grain
☐ Hardware
☐ Inspection Incomplete
☐ Instructions Incomplete/Unclear
☐ Maintenance
☐ Mislabeled
☐ Misread
☐ Offset
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions

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☐ Over/Under tolerance
☐ Part Incorrect
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☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other _____

# Picklist Print

*May-13-13 1:09:54 PM*

**Work Order ID:** 101610
**Parent Item:** D350-567-141
**Parent Item Name:** Floor Window Closeout Installation

**Start Date:** 5/31/13 **Required Date:** 5/31/13
**Start Qty:** 2.00 **Required Qty:** 2.00

| | | | | | | |
|---|---|---|---|---|---|---|
| MS21042L08 Nut | Purchased | No | 110 | Each | 4,721.0000 | 2 |

| Location | Loc Qty | Loc Code |
|---|---|---|
| ST315 | 2721 | |
| 122141 | 3 | |
| 122452 | 9 | |
| 122814 | 500 | |
| 123900 | 2209 | |
| ST505 | 2000 | |
| 125445 | 2000 | |

| | | | | | | |
|---|---|---|---|---|---|---|
| MS21042L3 Nut | Purchased | No | 110 | Each | 3,977.0000 | 5 |

| Location | Loc Qty | Loc Code |
|---|---|---|
| FP001 | 3 | |
| 122141 | 3 | |
| GA | 18 | |
| 122452 | 18 | |
| ST314 | 268 | |
| 117885 | 32 | |
| 119017 | 55 | |
| 119075 | 138 | |
| 123265 | 43 | |
| ST506 | 3688 | |
| 123900 | 954 | |
| 124291 | 2734 | |

| | | | | | | |
|---|---|---|---|---|---|---|
| MS21059L3 Nut Plate | Purchased | No | 110 | Each | 367.0000 | 2 |

| Location | Loc Qty | Loc Code |
|---|---|---|
| ST316 | 311 | |
| 124291 | 11 | |
| 125535 | 300 | |
| ST506 | 56 | |
| 124308 | 56 | |

DQA: _____ Date: _____

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

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**DISPOSITION**

- Rework ☐
- Scrap ☐
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- Work Order Update ☐

**AGAINST DEPARTMENT/PROCESS**

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

| Root Cause | | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Setup | ☐ | | | | | | | | | |
| Other | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

**FAULT CATEGORY**

**Landing Gear**

- ☐ Bending
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# Picklist Print

*May-13-13 1:09:55 PM*

**Work Order ID:** 101610
**Parent Item:** D350-567-141
**Parent Item Name:** Floor Window Closeout Installation

**Start Date:** 5/31/13 **Required Date:** 5/31/13
**Start Qty:** 2.00 **Required Qty:** 2.00

MS35206-229 Purchased No 110 Each 89.0000
Screw

| Location | Loc Qty | Loc Code |
|---|---|---|
| ST288 | 89 | |
| 123832 | 89 | |

NAS1149F0332P Purchased No 110 Each 8,438.0000
WASHER

| Location | Loc Qty | Loc Code |
|---|---|---|
| GA | 182 | |
| 122063 | 182 | |
| ST294 | 158 | |
| 122063 | 158 | |
| ST295 | 3 | |
| 123352 | 3 | |
| st510 | 8095 | |
| 123900 | 8095 | |

NAS1149FN616P Purchased No 110 Each 189.0000
WASHER

| Location | Loc Qty | Loc Code |
|---|---|---|
| ST294 | 189 | |
| 120560 | 189 | |

NAS1149FN816P Purchased No Each 669.0000
WASHER

| Location | Loc Qty | Loc Code |
|---|---|---|
| ST294 | 669 | |
| 117316 | 215 | |
| 121039 | 454 | |

DQA: _____ Date: _____

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

**AGAINST DEPARTMENT/PROCESS**

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

| Root Cause | | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Setup | ☐ | | | | | | | | | |
| Other | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

**FAULT CATEGORY**

**Landing Gear**

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

**General**

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

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# DART SERVICE INSTRUCTION

**TO AMEND INSTALLATION INSTRUCTIONS D350-567 REV. D OR EARLIER**
**AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-567 REV. 1 OR EARLIER**
REF CANADIAN STC: SH92-18
FAA STC: SH989NE
FAA STC: SH990NE

## 1.0 Purpose

The purpose of this service instruction is to add the D350-567-141 Close-out Kit, which is intended for customers wishing to operate their aircraft with the interior floor window removed. The D350-567-141 Floor Window Close-out Kit provides a barrier around the interior and exterior vertical reference floor window to prevent objects from falling into the aircraft controls when the interior floor window is removed as shown in Figure 1.

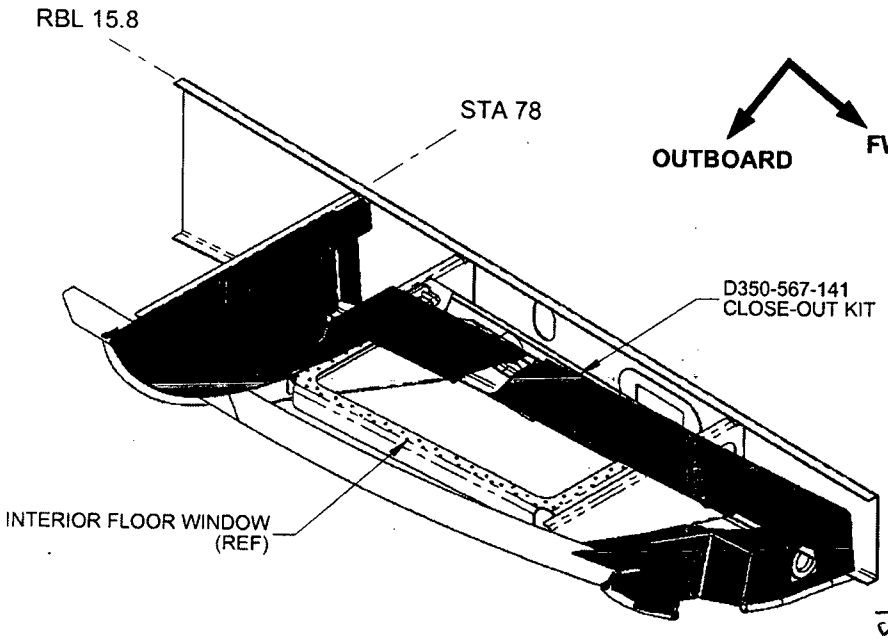



**Figure 1. Floor Window Close-out Kit Installation**

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| REV. | DESCRIPTION | BY | DATE |
|---|---|---|---|
| C | CORRECT TYPO NAS1149FN816P WAS NAS1149FN882P | RF | 12.03.13 |
| B | MS35206-229 WAS AN525-632R6; NAS1149FN616P (Qty 14) WAS (Qty 9); MS21042L06 (Qty 7) WAS (Qty 9); ADD AN525-832R7, NAS1149FN882P & MS21042L08 | RF | 12.02.22 |
| A | NEW ISSUE | RF | 12.01.09 |

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DRAWING NO. DSI 9590 REV. C
SHEET 1 OF 12

TITLE: FLOOR WINDOW CLOSE-OUT KIT
SCALE: NTS

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## 2.0 Part List

| Qty -141 | Part Number | Description |
|---|---|---|
| X | D350-567-141 | FLOOR WINDOW CLOSE-OUT KIT |
| | | |
| 1 | D3802-1-024 | SEAL (24") |
| 1 | D4434-041 | FWD BRACKET ASSEMBLY |
| 1 | D4434-047 | COVER ASSEMBLY |
| 1 | D4435-045 | T/R BELLCRANK COVER ASSEMBLY |
| 2 | D4435-9 | BRACKET |
| 1 | D4436-041 | AFT BRACKET ASSEMBLY |
| 1 | D4441-1-240 | RUBBER SEAL (24") |
| 7 | AN3-3A | BOLT |
| 2 | AN525-832R7 | SCREW |
| 7 | MS21042L06 | NUT (OR MS21042-06) |
| 2 | MS21042L08 | NUT (OR MS21042-08) |
| 5 | MS21042L3 | NUT (OR MS21042-3) |
| 2 | MS21059L3 | NUTPLATE |
| 7 | MS35206-229 | SCREW |
| 12 | NAS1149F0332P | WASHER (AN960-10L) |
| 14 | NAS1149FN616P | WASHER (OR AN960-6L) |
| 2 | NAS1149FN816P | WASHER (OR AN960-8L) |

C

## 3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141 Kit.

| Installation | Weight | LATERAL | | LONGITUDINAL | |
|---|---|---|---|---|---|
| | | Arm | Moment | Arm | Moment |
| **D350-567-141** Floor Window Close-out Kit | 3.9 lb<br>1.77 kg | 17.9 in<br>0.45 m | 69.8 in-lb<br>0.80 m-kg | 65.5 in<br>1.66 m | 255.5 in-lb<br>2.94 m-kg |

## 4.0 Installation Procedure

Notes:

1) Figure 2 shows the general arrangement and installation of the D350-567-141 Close-out Kit. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
2) In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.
   - D350-567-115 — OK to remove D3295-041
   - D350-567-031 — OK to remove D3212-1
   - D350-567-011 — OK to remove D2214
   - D350-567-021 — OK to remove D2951
3) It is acceptable to drill/trim the D350-567-141 Close-out Kit as required to improve fit.

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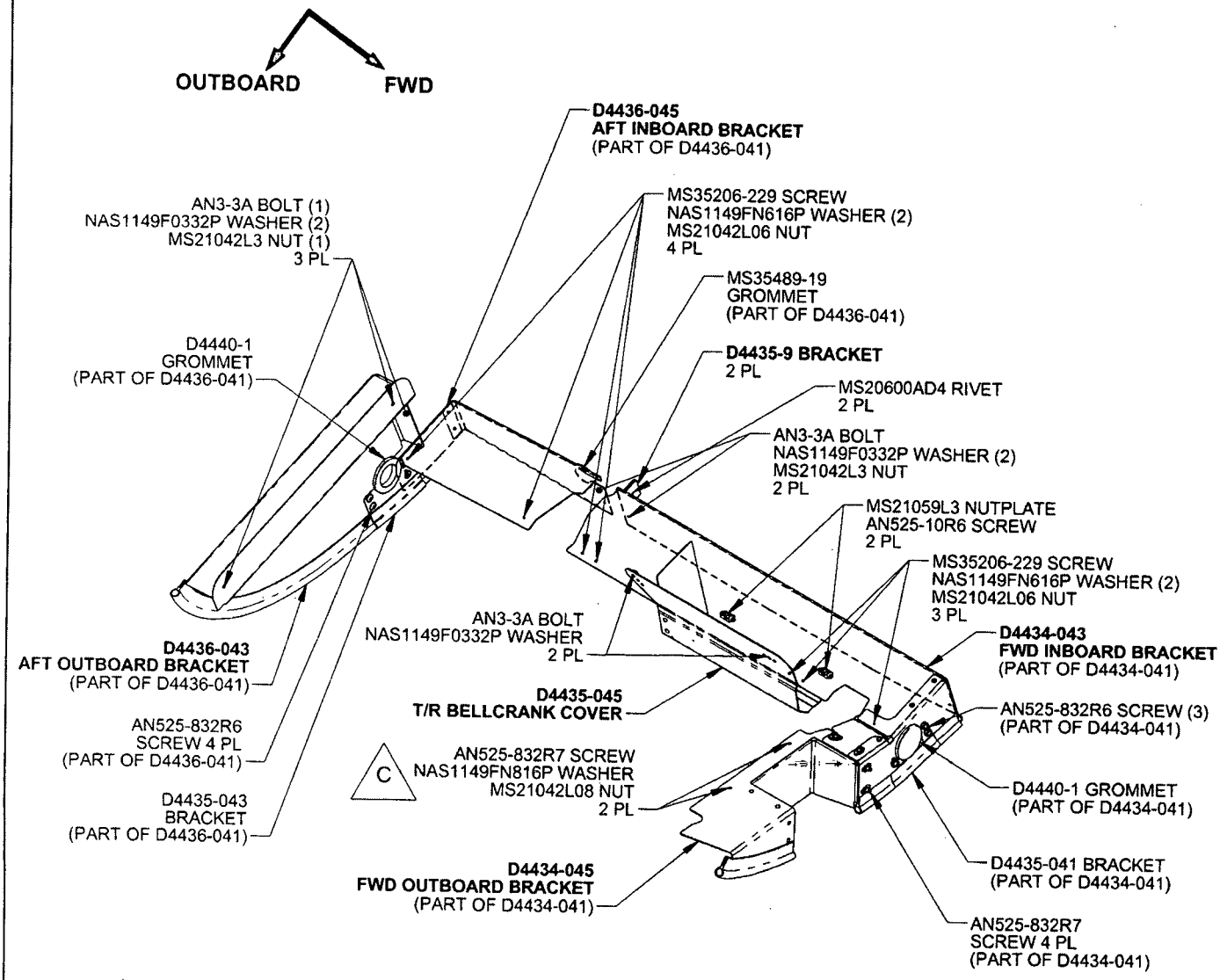



**Figure 2. Floor Window Close-out Kit Installation**

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4.1 Temporarily install D4436-043 Aft Outboard Bracket and D4436-045 Aft Inboard Bracket using clecos and/or clecos clamps. Before drilling holes:
   a) Position the D4436-043 Aft Outboard Bracket so the flange contacts the main beam as shown in Figure 3.
   b) Confirm that the D4436-043 Aft Outboard Bracket and beam angle are parallel as shown in Figure 4.

4.2 Temporarily install D4434-043 Fwd Inboard Bracket and D4434-045 Fwd Outboard Bracket using clecos and cleco clamps. Confirm there is no contact between D4436-045 Aft Inboard Bracket and D4434-043 Fwd Inboard Bracket and main beam gusset as shown in Figure 5.

4.3 If aircraft is equipped with Collective Circuit Breaker Board box trim D4434-043 Fwd Inboard Bracket as shown in Figure 14. Install D4434-047 Cover as shown in Figure 13. Note: Confirm the D4434-047 Cover fits over the Collective Circuit Breaker Board box. Adjust opening as required.

4.4 Drill off rivets holding plastic wire bundle stand offs. Transfer drill ø0.144 holes to D4436-045 Aft Inboard Bracket per Figure 6. Transfer drill 2 x ø0.144 holes to D4434-043 Fwd Inboard Bracket per Figure 7. Transfer drill 2 x ø0.144 holes for D4434-043 Fwd Inboard Bracket per Figure 8. Before drilling confirm the D4434-043 and D4436-045 brackets are flush with outboard edge of main beam flange. Assemble D4436-045 Aft Inboard Bracket and D4434-043 Fwd Inboard Bracket and wire bundle stand offs to main beam flange using MS35206-229 screw, NAS1149FN616P washer and MS21042L06 nut.

4.5 Install D4436-043 Aft Outboard Bracket using AN3-3A bolt and NAS1149F0332P washer and MS21042L3 nut per Figure 9.

4.6 Remove 2 rivets holding RH heating plastic stand off as shown in Figure 10. Position the D4435-9 Brackets on the in/outboard sides of the cross beam and transfer drill 2 x ø0.129 holes from crossbeam to both D4435-9 Brackets. Install D4435-9 Brackets and RH heating plastic stand off using MS20600AD4 rivets or equivalent.

4.7 Drill a pilot hole from D4435-9 Bracket to the D4434-045 Fwd Inboard Bracket and D4436-045 Aft Inboard Bracket and open to ø0.191. Install AN3-3A bolt, NAS1149F0332P washer and MS21042L3 nut as shown in Figure 10. Be sure to maintain edge distance.

4.8 Transfer drill 2 x ø0.144 holes from crossbeam to D4434-045 Fwd Outboard Bracket if holes exist in crossbeam. If holes do not exist, drill 2 x ø0.144 holes at either end of D4434-045 bracket as shown in Figure 11. Install AN525-832R7 Screws, NAS1149FN816P washer and MS21042L08 nuts. C

4.9 Align D4435-045 T/R Bellcrank Cover with existing holes in RH seat track lower frame and temporarily install using clecos and/or cleco clamps as shown in Figure 12.

4.10 Transfer drill 2 x ø0.098 holes from D4435-045 T/R Bellcrank Cover to D4434-043 Fwd Inboard Bracket. Open holes to ø0.191 and install MS21059L3 nut plate into D4434-043 Fwd Inboard Bracket as shown in Figure 12 and Figure 13. Install D4435-045 T/R Bellcrank Cover using AN525-10R6 screw, AN3-3A bolt and NAS1149F0332P washer per Figure 12 and Figure 13.

4.11 The D4440-1 grommets are provided to facilitate the routing of wiring harness thru the close-out kit as required. The wiring harness should be secure to the aircraft structure per AC 43.13.13-1B or AS350 Chapter 20.02.01.

4.12 Use the D3802-1-024 Seal to fill gaps between the brackets and the cowlings that are larger than 0.25 inch.

4.13 Perform travel/interference check of the flight controls to ensure there is no interference and all controls still have full travel.

4.14 Ensure there is a gap between the components of the D350-567-141 Close-out Kit and the aircraft structure so that the Close-out Kit does not chafe, interfere, or cause damage to the surrounding aircraft structure. In areas where the D350-567-041 Close-out Kit may contact the aircraft structure, protect from abrasion using chafing tape or a layer Proseal 890 or MIL-S-8802 class B2 sealant or equivalent as required.

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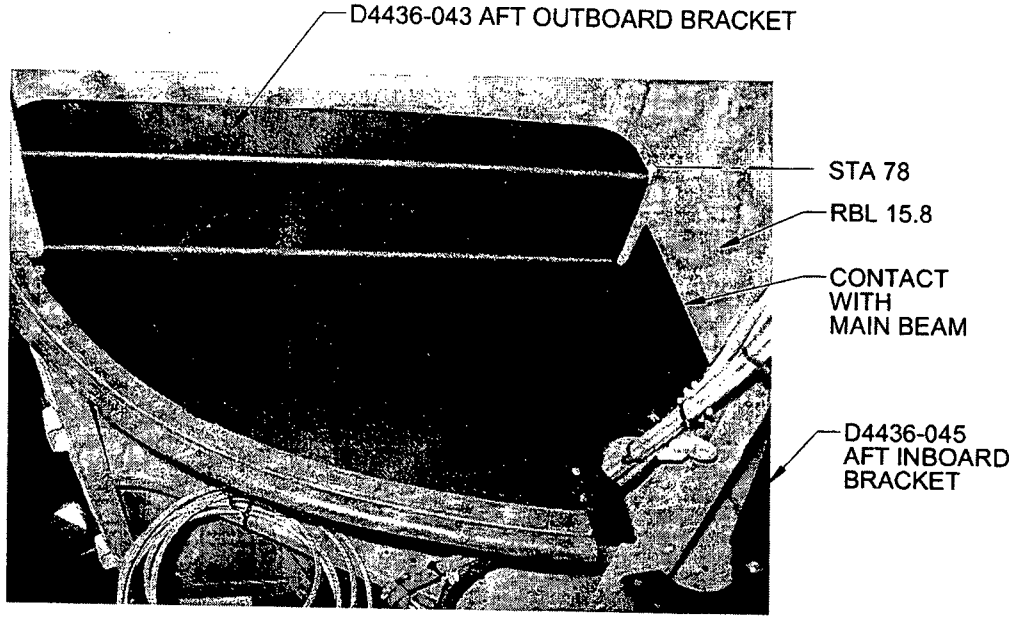



**Figure 3. D4436-043 Aft Outboard Bracket Installation**

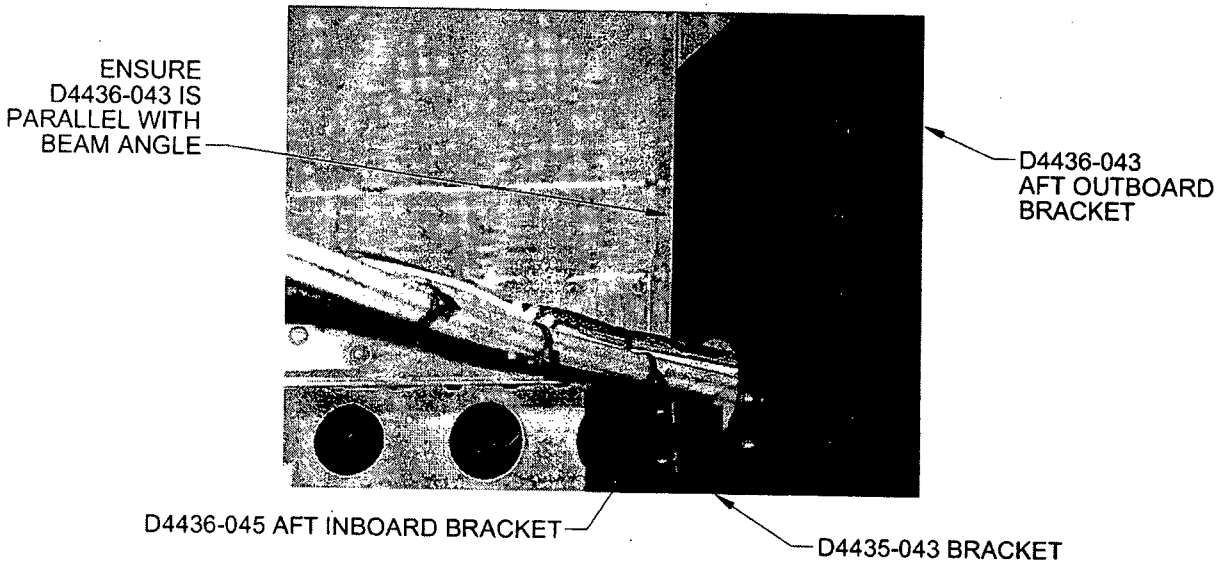



**Figure 4. D4436-043 & D4435-043 Brackets Installation**

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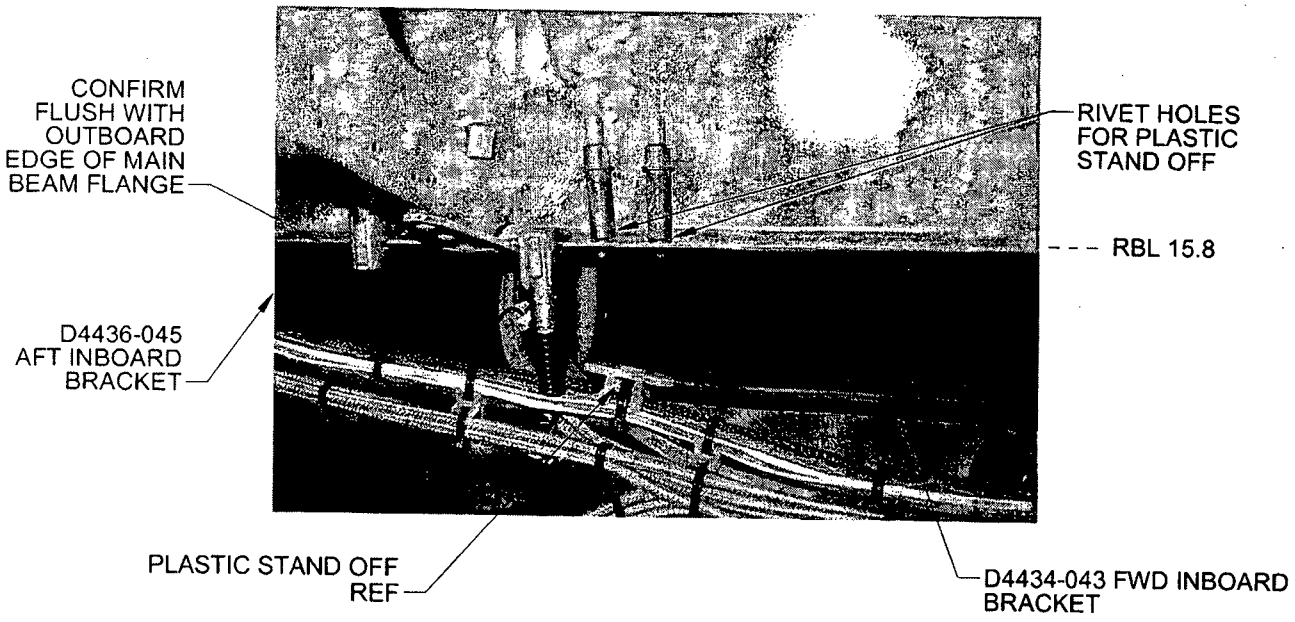



**Figure 7. D4434-043 & D4436-045 Brackets Installation**

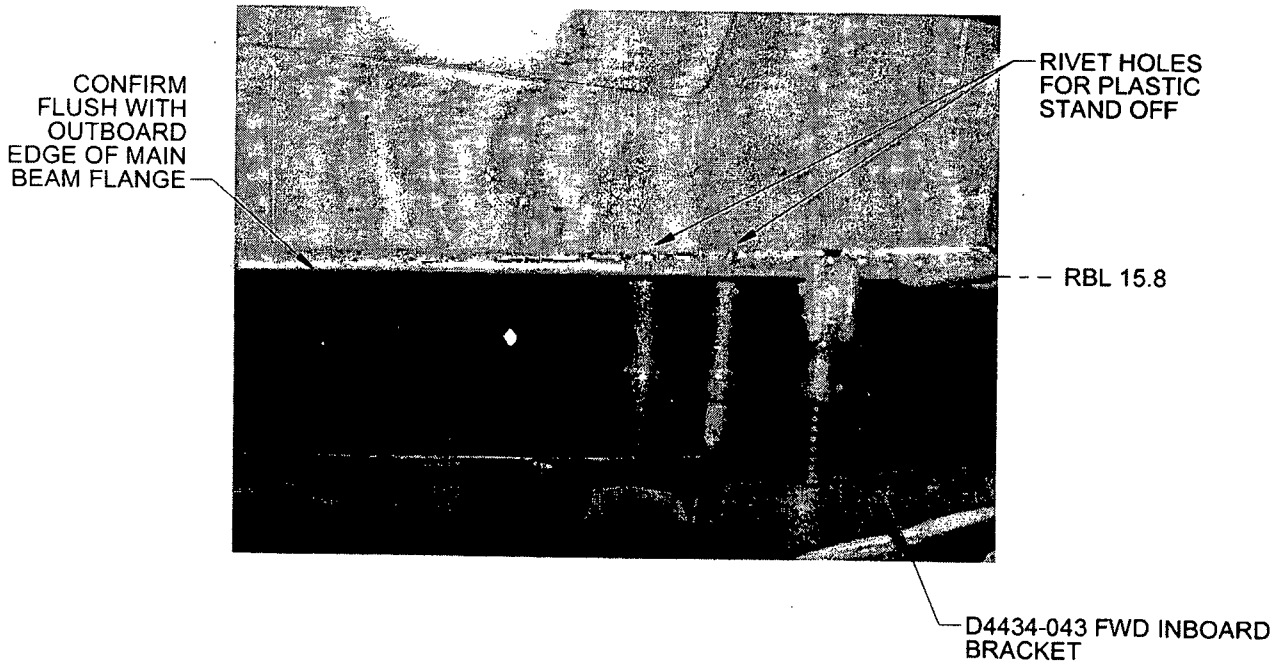



**Figure 8. D4434-043 Fwd Inboard Bracket Installation**

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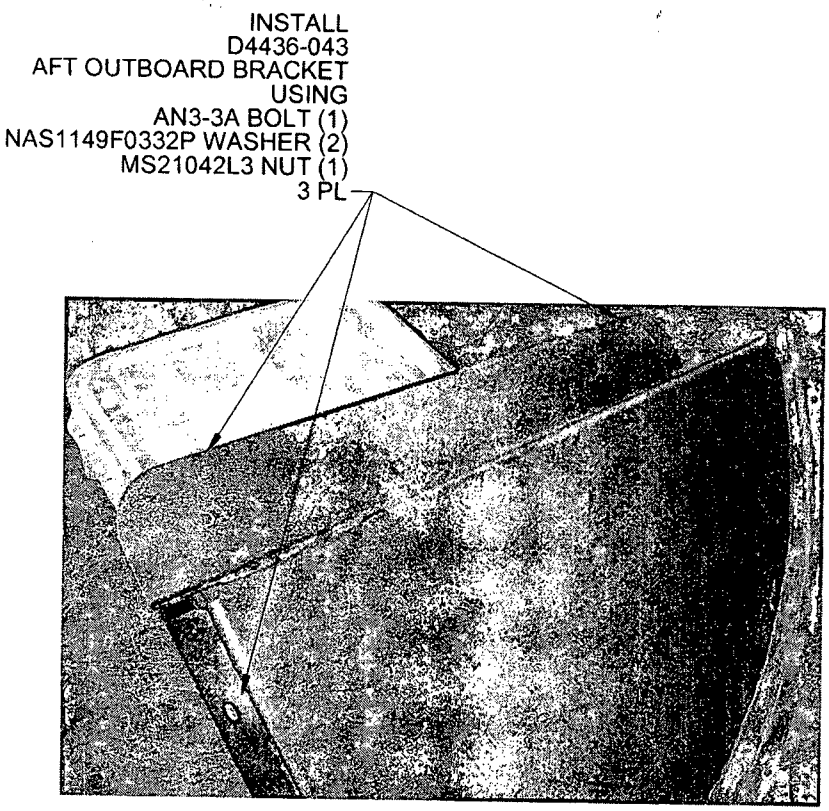



**Figure 9. D4436-043 Aft Outboard Bracket Installation**

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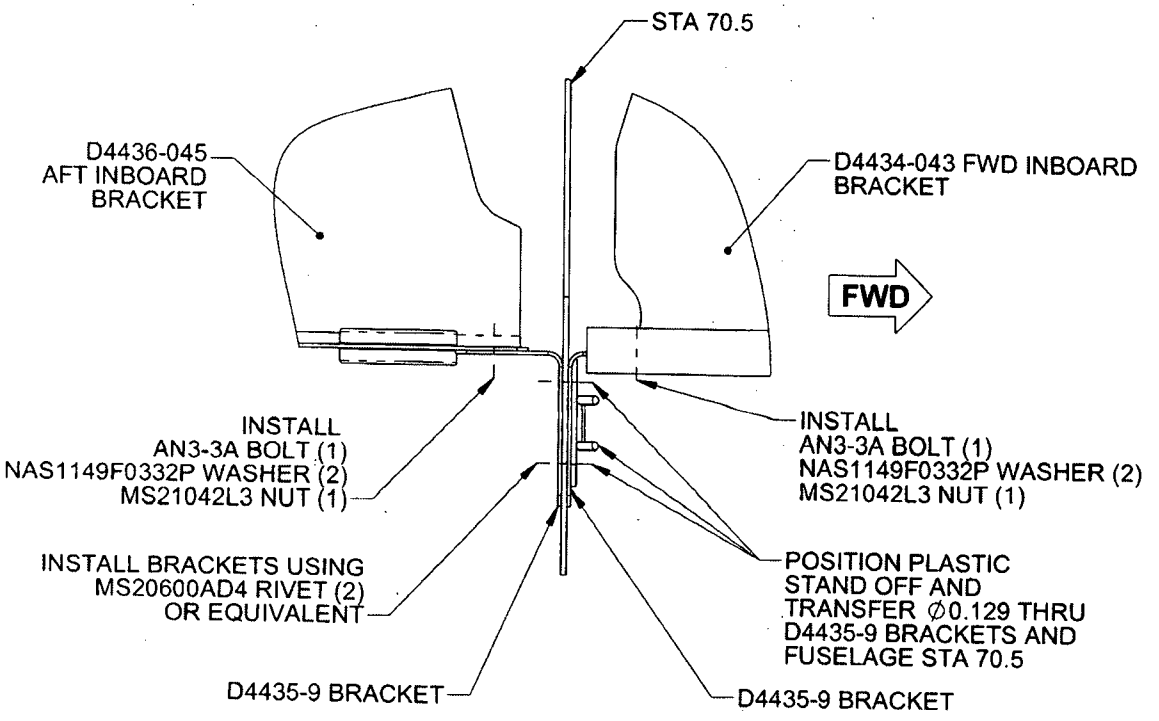
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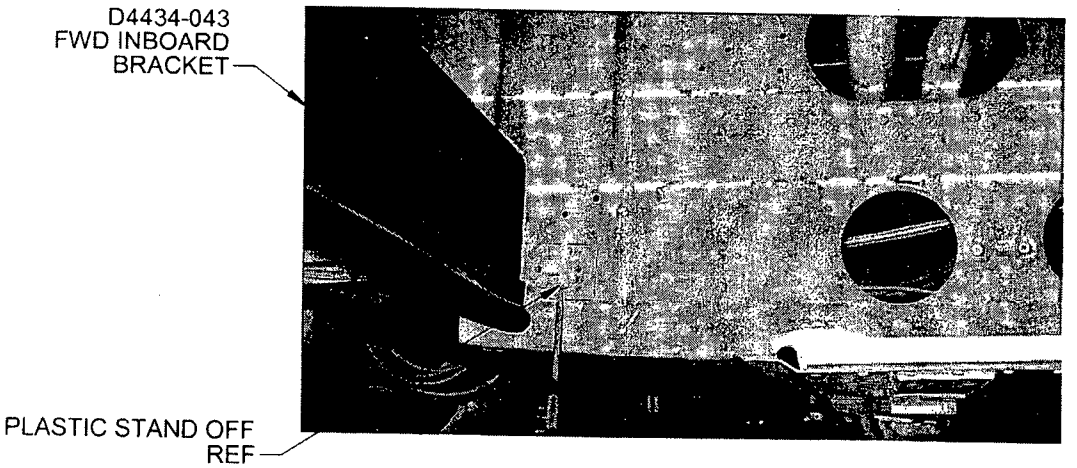



**Figure 10. D4434-043 and D4435-9 Brackets Installation**

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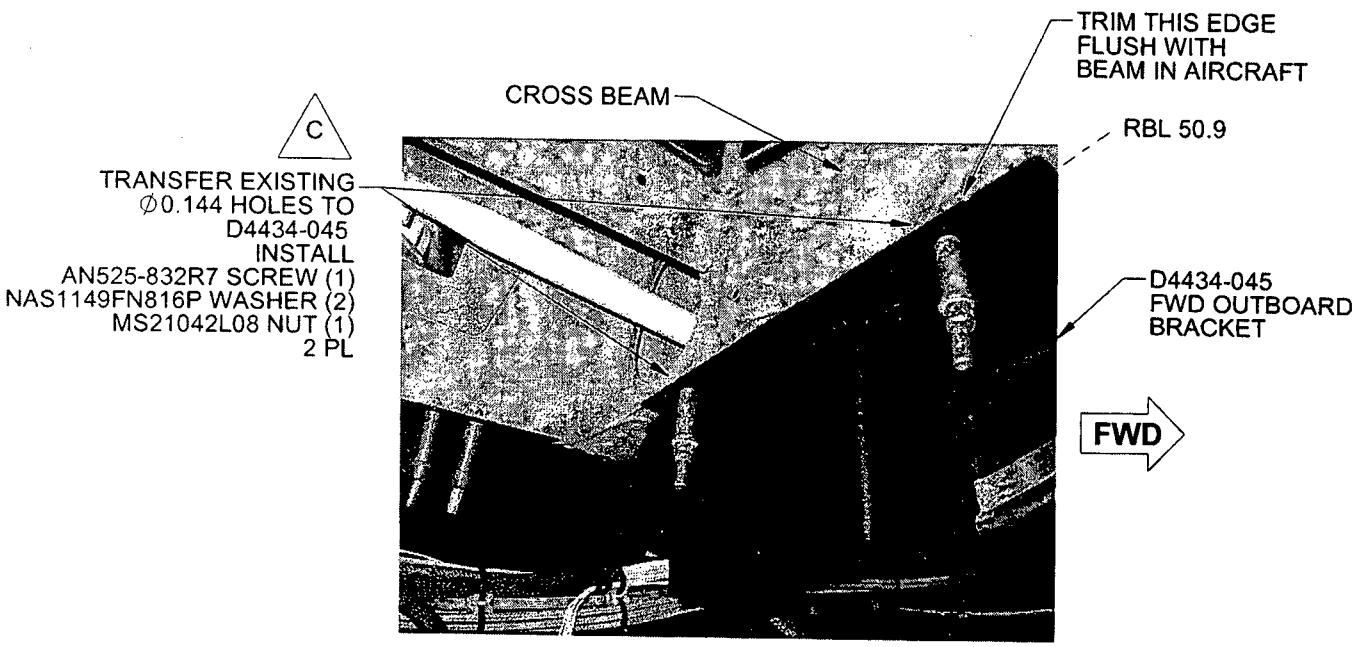



**Figure 11. D4434-045 Bracket Installation**

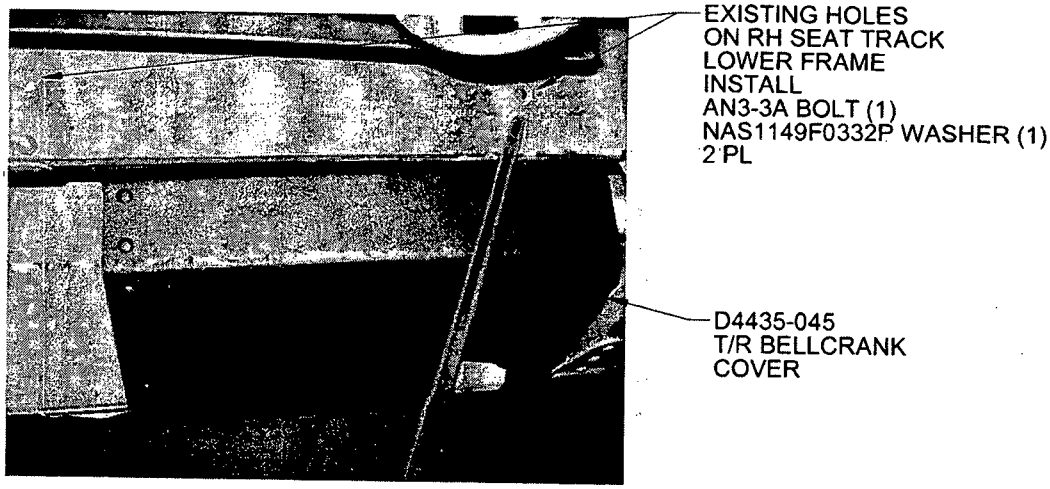



**Figure 12. D4435-045 T/R Bellcrank Cover Installation**

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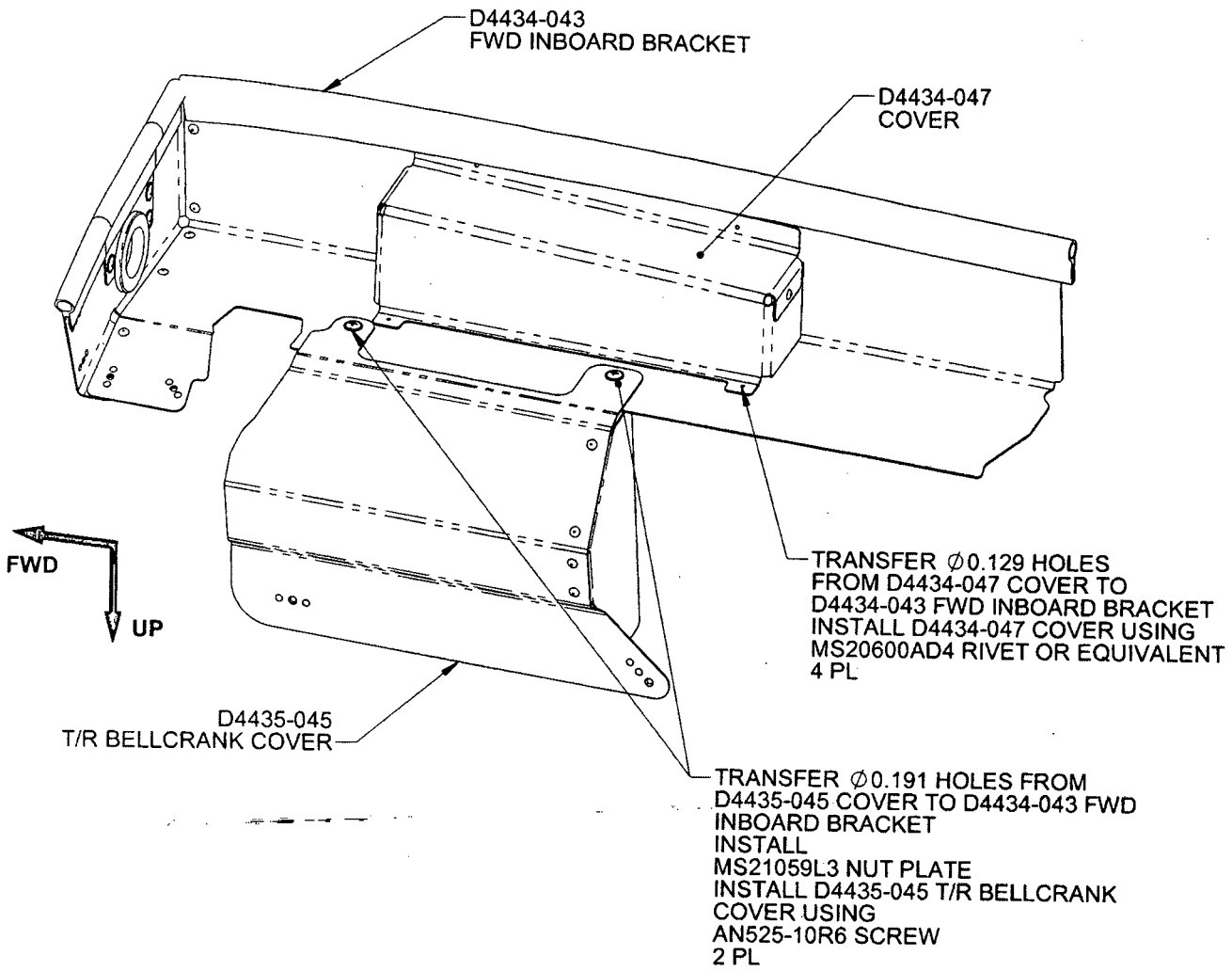



**Figure 13. D4435-045 & D4434-047 Cover Installation**

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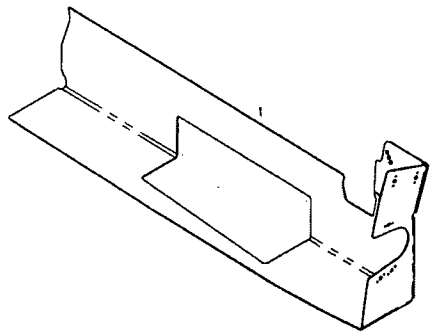
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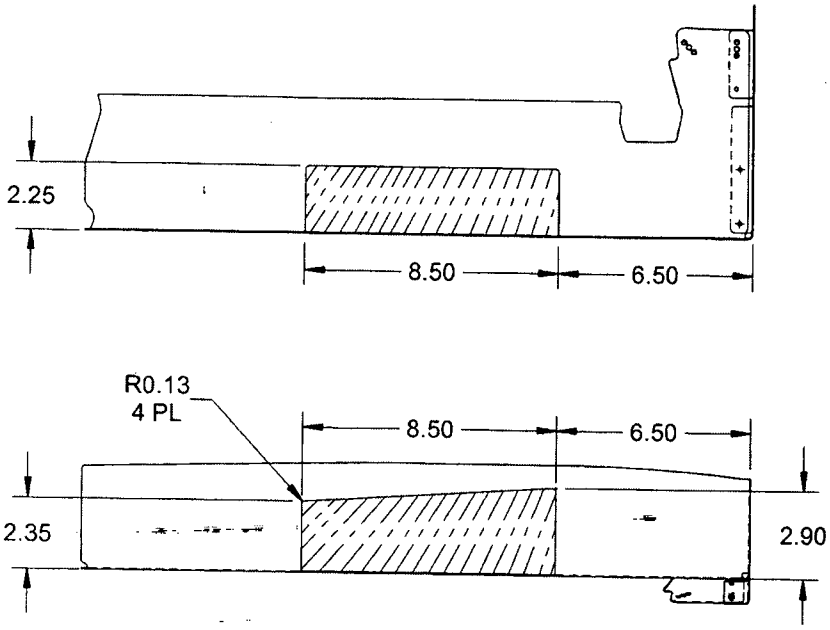



**Figure 14. D4434-043 Fwd Inboard Bracket Cutout**

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

**APPROVED**

BY: _____
D. SHEPHERD (DE # 02)

DATE: 12.03.13
CERT. NO.: SH92-18
ISSUE NO.: 6

| | |
|---|---|
| DESIGN | RF |
| DRAWN | RF |
| CHECKED | |
| MFG. APPR. | N/A |
| APPROVED | |
| DE APPR. | |
| DATE | 12.03.13 |

**DART AEROSPACE LTD**
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. DSI 9590 REV. C
SHEET 12 OF 12

TITLE
FLOOR WINDOW CLOSE-OUT KIT
SCALE NTS

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C1012

## 2.0 Part List

| Qty -141 | Part Number | Description |
|---|---|---|
| X | D350-567-141 | FLOOR WINDOW CLOSE-OUT KIT |
| 1 | D3802-1-024 | SEAL (24") |
| 1 | D4434-041 | FWD BRACKET ASSEMBLY |
| 1 | D4434-047 | COVER ASSEMBLY |
| 1 | D4435-045 | T/R BELLCRANK COVER ASSEMBLY |
| 2 | D4435-9 | BRACKET |
| 1 | D4436-041 | AFT BRACKET ASSEMBLY |
| 1 | D4441-1-240 | RUBBER SEAL (24") |
| 7 | AN3-3A | BOLT |
| 2 | AN525-832R7 | SCREW |
| 7 | MS21042L06 | NUT (OR MS21042-06) |
| 2 | MS21042L08 | NUT (OR MS21042-08) |
| 5 | MS21042L3 | NUT (OR MS21042-3) |
| 2 | MS21059L3 | NUTPLATE |
| 7 | MS35206-229 | SCREW |
| 12 | NAS1149F0332P | WASHER (AN960-10L) |
| 14 | NAS1149FN616P | WASHER (OR AN960-6L) |
| 2 | NAS1149FN816P | WASHER (OR AN960-8L) |

C

## 3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141 Kit.

| Installation | Weight | LATERAL | | LONGITUDINAL | |
|---|---|---|---|---|---|
| | | Arm | Moment | Arm | Moment |
| **D350-567-141** Floor Window Close-out Kit | 3.9 lb<br>1.77 kg | 17.9 in<br>0.45 m | 69.8 in-lb<br>0.80 m-kg | 65.5 in<br>1.66 m | 255.5 in-lb<br>2.94 m-kg |

## 4.0 Installation Procedure

Notes:

1) Figure 2 shows the general arrangement and installation of the D350-567-141 Close-out Kit. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
2) In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.
   - D350-567-115 — OK to remove D3295-041
   - D350-567-031 — OK to remove D3212-1
   - D350-567-011 — OK to remove D2214
   - D350-567-021 — OK to remove D2951
3) It is acceptable to drill/trim the D350-567-141 Close-out Kit as required to improve fit.

CANADA
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BRANCH
DAO # 01-O-01

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**DART AEROSPACE LTD**
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. DSI 9590 REV. C
SHEET 2 OF 12
TITLE FLOOR WINDOW CLOSE-OUT KIT SCALE NTS

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**DART AEROSPACE LTD**
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. DSI 9590 REV. C
SHEET 2 OF 12

TITLE FLOOR WINDOW CLOSE-OUT KIT SCALE NTS

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# Work Order ID 101610

*101610*



*May-13-13 1:09:55 PM*

**Item ID:** D350-567-141 **Accept** *N900040100* **Setup Start** *NS1*

**Revision ID:** **Stop** *NS2*

**Item Name:** Floor Window Closeout Installation

**Start Date:** 5/31/13 **Start Qty:** 2.00 *2* **Cust Item ID:**

**Required Date:** 5/31/13 **Req'd Qty:** 2.00 *2* **Customer:**

**Reference:**

**Approvals:** **Process Plan:** MLJ **Date:** 13-05-15 **Tooling:** **Date:** **Run Start** *NR1*

**QC:** **Date:** **SPC (Y/N):** **Date:** **Stop** *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| Draw Nbr: DSI 9590 | Revision Nbr: C | | | | | | | | |
| 100 | DOCUMENT CONTROL | 0.00 | | | | | | | |
| *100* | | | | | | | | | |
| DC | **Memo** | 0.00 | | | | | | | |
| Document Control | Photocopy bluefile & type labels per PPP D350-567-141 CHG002 | | | | | | | | |
| 110 | Pick Kit | 0.00 | | | | | | | |
| *110* | | | | | | | | | |
| Packaging | **Memo** | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |
| 120 | QC4- 100% Inspect kits for completeness | 0.00 | | | | | | | |
| *120* | | | | | | | | | |
| QC | **Memo** | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

MLJ 13-06-14

2x

13-6-13